

# Work Order ID 67911

Monday, April 04, 2011 2:23:40 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: *11-04-11*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4042

A

100

Weld per dwg A/R S.S. rod Batch: *1114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A  
\*\*\*inspect before welding mesh\*\*\*  
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

*11-04-11* (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*QC-11-04-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

1

BR 11-4-12.

W/O:		WORK ORDER CHANGES						
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Reference:

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

*M 116 964.*

1ST COAT:

START TIME: *2:45*

OVEN TEMPERATURE: *400*

FINISH TIME: *3:15*

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1 BR 11-4-12.*

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*EP 11/04/13 @*

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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

*EP* 4/4/13 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*ml* 11 04 13 ①

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

*w/o*  
*67910*

*EP* 4/4/13 ①

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/14  
MF  
11-04-13

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Page 1

Work Order ID: 67911

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011





Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A  Bolt		Purchased	No			150	Each	34.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST351		34							
				116400		34							
AN960JD8  Washer	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2			
						M 117316							
D2581  Mounting Bracket		Manufactured	No			100	Each	32.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA005		32							
				66500		10							
				66806		22							
D2931  Bumper		Manufactured	No			150	Each	696.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST504		696							
				46064		696							

SB 11/6/13

6

2

2

SB 11/6/13

2

11.04.07

(24)

2

SB 11/6/13

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-1

Manufactured No

100

Each

2.0000

1

1



*SY* 11.04.08

Rib

Location

Loc Qty

Loc Code

WA006

2

66629

2

D3913-15

Manufactured No

100

Each

5.0000

1

1



*SY* 11.04.08

Wide Handle Plate

Location

Loc Qty

Loc Code

WA

3

67751

3

WA005

2

66695

2

D3913-3

Manufactured No

100

Each

4.0000

1

1



*SY* 11.04.08

Rib

Location

Loc Qty

Loc Code

WA006

4

65314

1

67475

3

D3913-7

Manufactured No

100

Each

6.0000

2

2



*SY* 11.04.08

Rib

Location

Loc Qty

Loc Code

WA006

6

65278

1

66435

5

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Page 2

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011


Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-9  
  
 Manufactured No  
 Hinge Rib


100 Each 4.0000

1 1  
  
 11.04.08

Location	Loc Qty	Loc Code
WA006	4	
66630	2	
67126	2	

D3916-041  
  
 Manufactured No  
 Rib Assembly


100 Each 7.0000

2 2  
  
 11.04.08

Location	Loc Qty	Loc Code
WA	7	
65921	1	
67276	6	

D3916-5  
  
 Manufactured No  
 Light Rib

100 Each 5.0000

3 3  
  
 B67979 11.04.08

Location	Loc Qty	Loc Code
WA	5	
66696	5	

D4016-1  
  
 Manufactured No  
 Hinge Half, Base

100 Each 31.0000

3 3  
  
 11.04.08

Location	Loc Qty	Loc Code
WA	18	
66418	0	
67473	18	
WA005	13	
66418	13	

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

3.0000

1

1



Rib



*SY* 11.04.08

Location

Loc Qty

Loc Code

WA005

3

66885

3

D4017-9

Manufactured No

100

Each

4.0000

2

2



Rib



*SY* 11.04.08

Location

Loc Qty

Loc Code

WA006

4

66886

4

D4020-11

Manufactured No

100

Each

14.0000

2

2



End Mesh, Basket



*SY* 11.04.08

Location

Loc Qty

Loc Code

WA

14

61306

1

67094

4

67458

9

D4021-1

Manufactured No

100

Each

21.0000

3

3



Handle Plate



*SY* 11.04.08

Location

Loc Qty

Loc Code

WA

13

67474

13

WA005

8

66697

8

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Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

9.0000

2

2



Blanking Plate



SA 11/04/13

Location

Loc Qty

Loc Code

WA005

9

67008

9

2

D4034-041

Manufactured No

100 Each

3.0000

1

1



Aft Upper Rib Assembly



SY 11.04.08

Location

Loc Qty

Loc Code

WA006

3

66884

3

(IX)

D4034-043

Manufactured No

100 Each

2.0000

1



Fwd Upper Rib Assembly



SY 11.04.08

Location

Loc Qty

Loc Code

WA006

2

66883

2

(IX)

M304EX0.75-16F

Purchased No

100 sf

530.0526

33

33



Expanded Metal Flat SS



SY 11.04.08

Location

Loc Qty

Loc Code

WA

530.0526

115012

150

117197

380.0526

33

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Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

931.0000

2

2



Cherry Rivets

SP 11/04/13

Location

Loc Qty

Loc Code

ST321

494

111636

494

WA018

437

107939

437

2

MS21042L3

Purchased

No

150

Each

2,074.000

6

6



Nut

SP 11/04/13

Location

Loc Qty

Loc Code

ST300

2074

116391

474

116540

800

116549

800

6

NAS1149F0332P

Purchased

No

150

Each

22.0000

12

12



WASHER

SP 11/04/13

Location

Loc Qty

Loc Code

ST275

22

18057

22

1117317

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

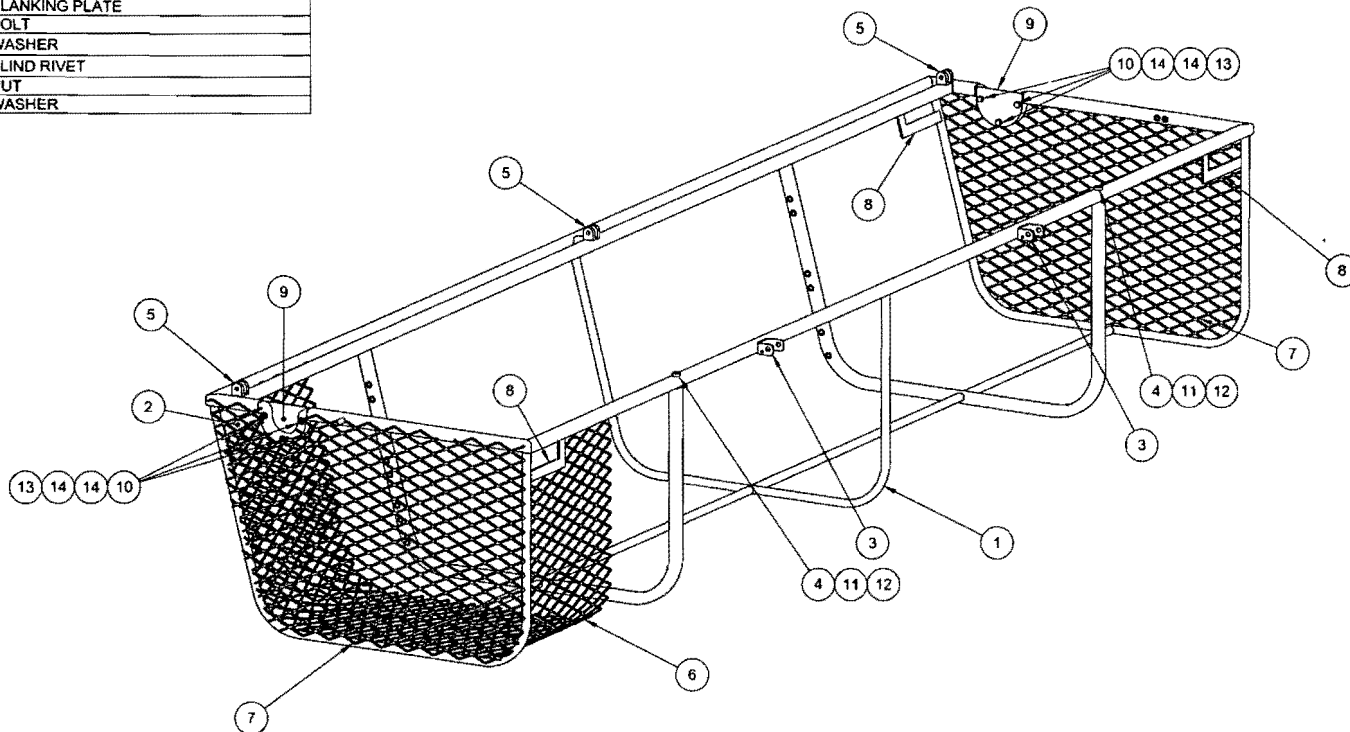
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
WJD

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A  
SHEET 1 OF 6  
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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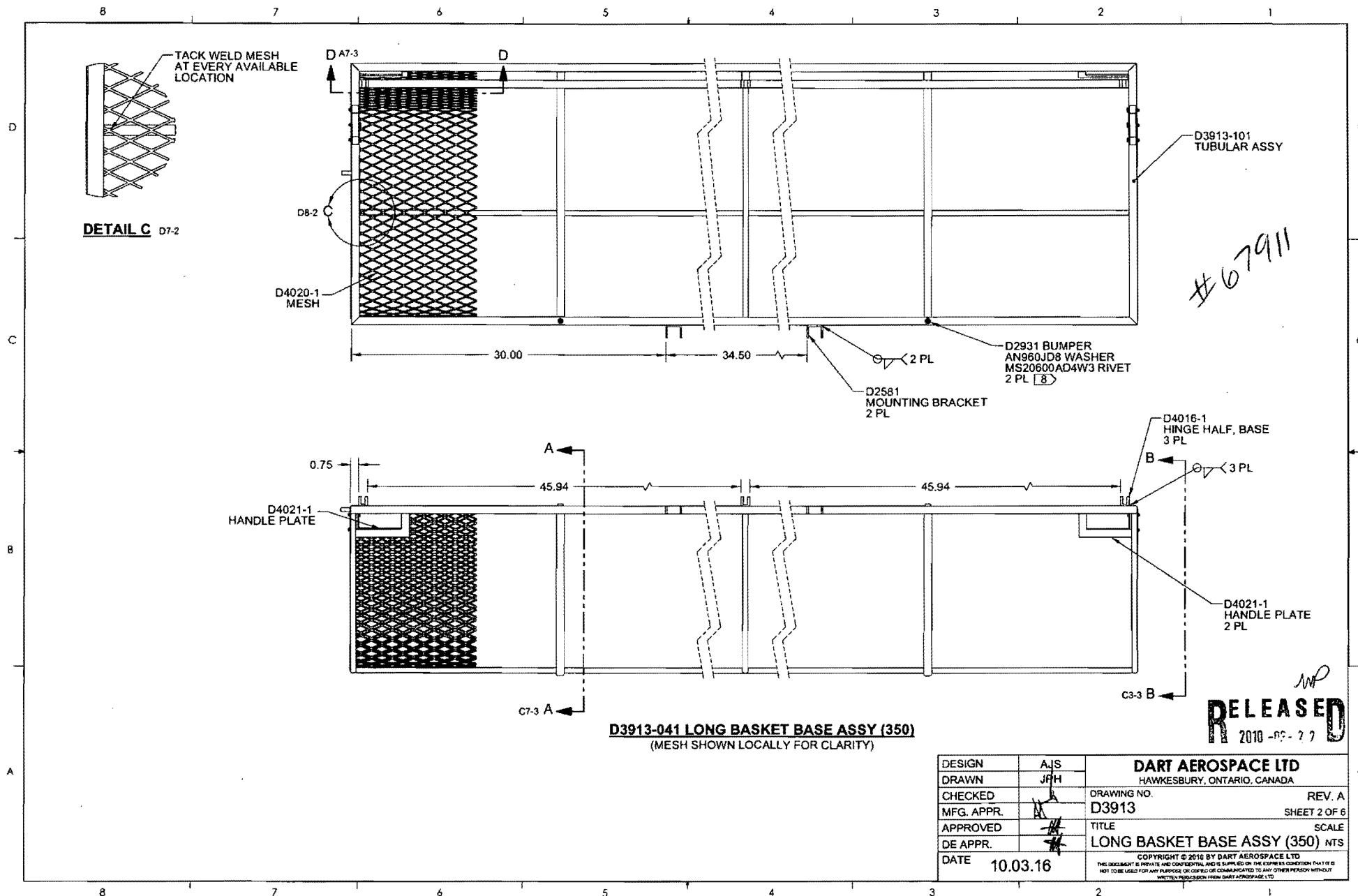
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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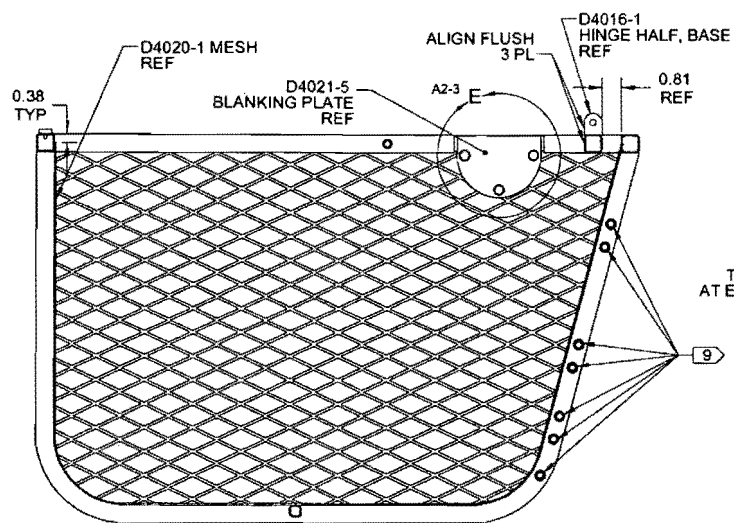
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

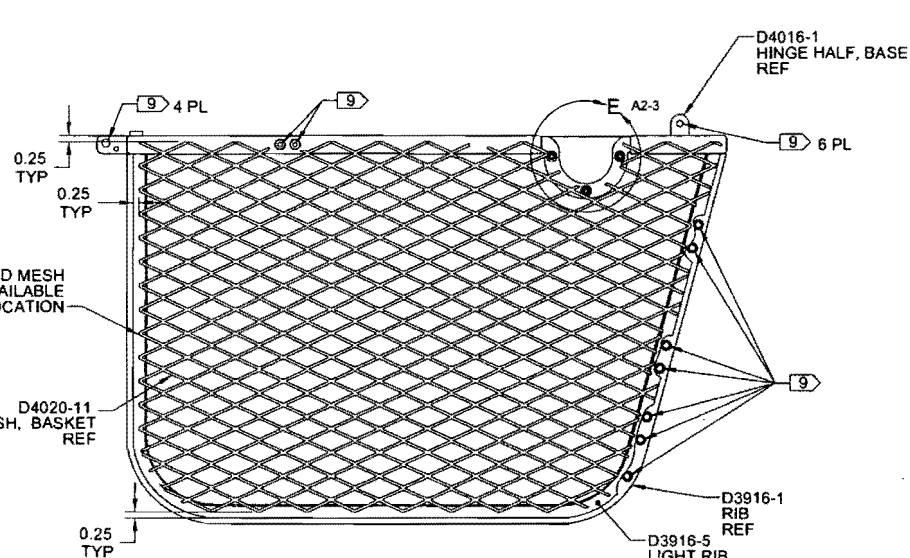
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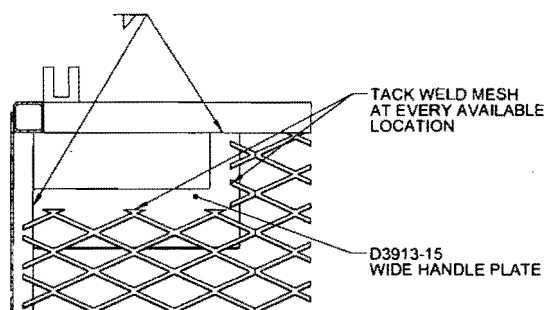
**NOTE:** Date & initial all entries



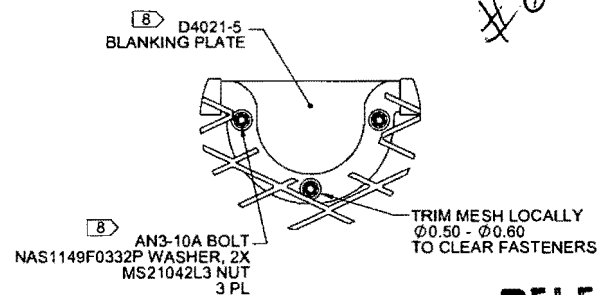
**SECTION A-A** A5-2



**VIEW B-B** A2-2







**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL E** D2-3  
D6-3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

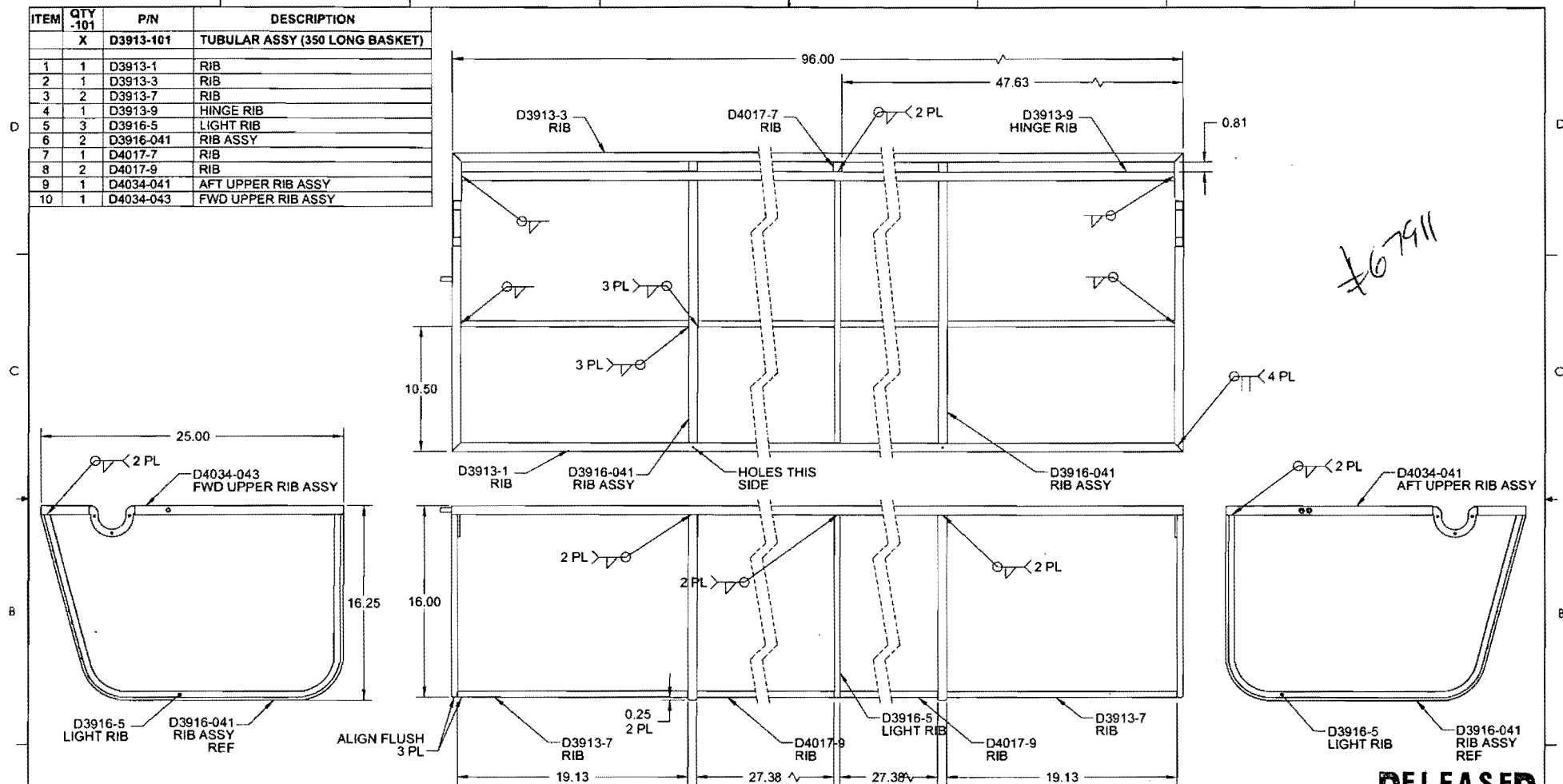
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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APPROVED		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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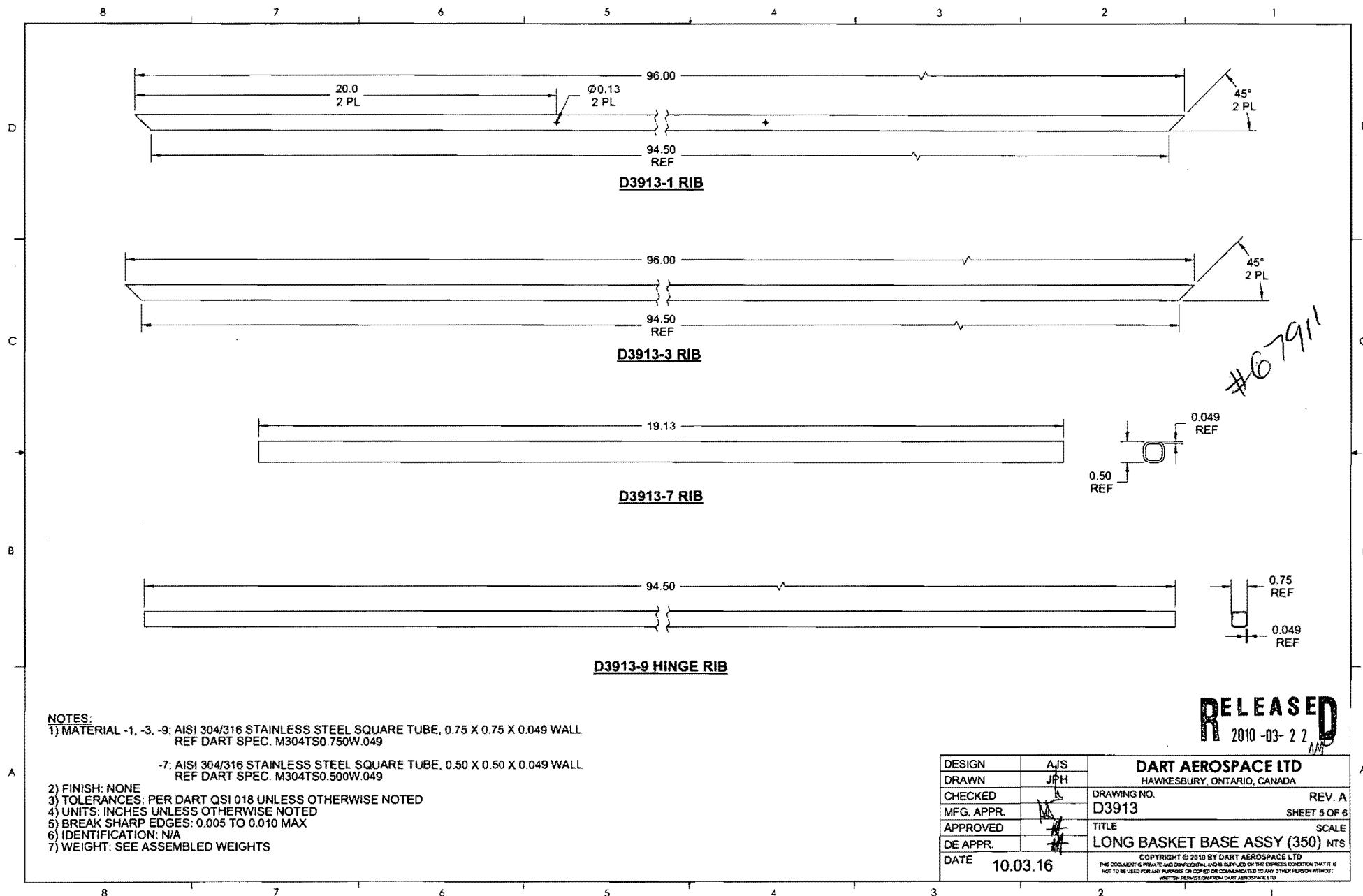
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

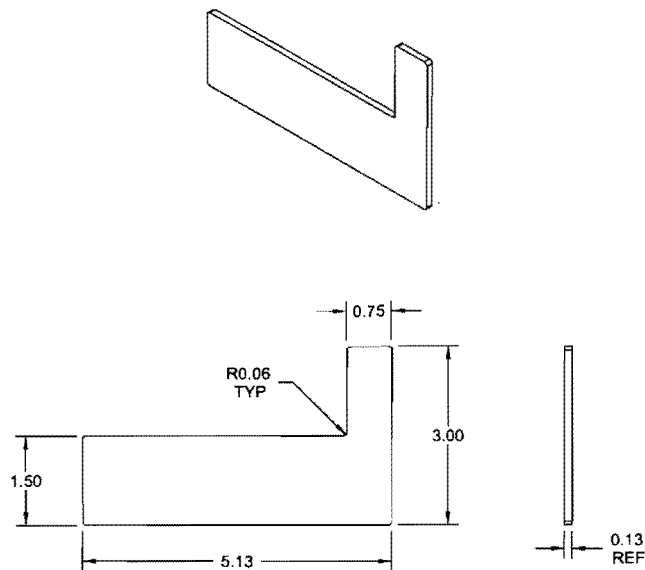
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries